

Work Order ID 125617-1

Thursday, October 16, 2014 2:21:40 PM

125617

Page 1

Item ID: D4941-4L08

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Floor Protector, Aft RH, (Clear)

Start Date: 10/17/14 Start Qty: 5.00

5

Cust Item ID:

Required Date: 10/24/14 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

14-10-15

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4941

D

100

0.00

100

HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks

DAS

07

9-29

x5

14/10/14

105

0.00

105

Dry Material

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

DAS

07

9-29

x5

14/10/14

Temp: 245 deg. F

Time IN: 5:00 PM

Time OUT: 6:00 AM

OCT 15 2014

Per: [Signature]

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Item ID: D4941-4L08 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Floor Protector, Aft RH, (Clear)
 Start Date: 10/17/14 Start Qty: 5.00 *5* Cust Item ID:
 Required Date: 10/24/14 Req'd Qty: 5.00 *5* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* Thermoform Thermoforming Machine	THERMOFORMING MACHINE Memo Thermoform as per Dwg. D4941 and Folio FTA 161 Dwg. Rev. <u>DC</u> Folio Rev. <u>EC</u>	0.00 0.00				x5			DAS 07 9-89 14/10/16
130 *130* Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING Memo Trim to Finished Dimensions	0.00 0.00				x1			DAS 07 9-89 14/10/23
140 *140* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				x1			DAS 07 9-89 14/10/27

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Accept

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Stop *NR2*

Insp.
Stamp

0.00

0.00

Memo

0.00

0.00

0,00

Memo

0,00

0.00

0.00

Memo

0.00

CAS
05
9-69

OCT 28 2014

① 14.10-27 P2

14/10/28 DJ

mf
14-10-28

Picklist Print

Thursday, October 16, 2014 2:21:44 PM

Page 1

Work Order ID: 125617

125617

Parent Item: D4941-4L08

D4941-4L08

Parent Item Name: Floor Protector, Aft RH, (Clear)

Start Date: 10/17/14

Required Date: 10/24/14

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev A New Issue 13/12/16 DL
Revised dimensions 14/02/12 DL
14/07/02 DL

IPP Rev. B
IPP Rev C revised Dwg.
IPP Rev. D Revised Dwg. 14/07/25 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No			100	sf	2,251.508	4.875	25			DAS 07 9-89

MI FXS 118-90318-08

Lexan Sheet

**

Location

Loc Qty

Loc Code

therm

2251.508

113127

8

m126994

2243.508

17/10/27

25 sg ft.

DART AEROSPACE LTD		Work Order:	125617
Description: Floor Protector, RH Aft		Part Number:	D4941-4L02/L08
Inspection Dwg: D4941	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: DAS 07 9-89 Date: 14/10/16

TRIMMING SECTION

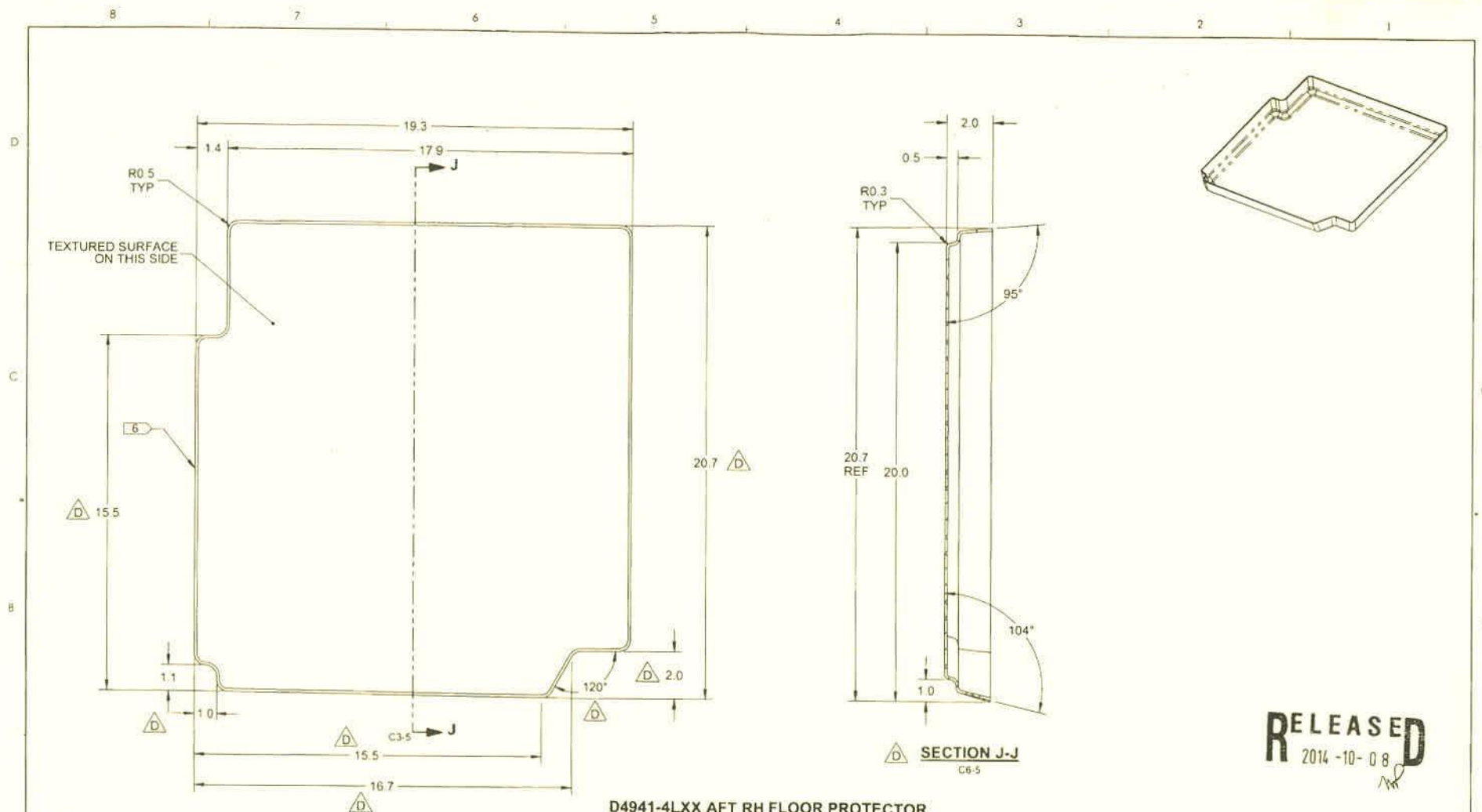
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
19.3	+/-0.100	19.25"	✓			
17.9	+/-0.100	17.9"	✓			
20.3 <u>th</u>	+/-0.100	20.6"	✓			
1.0 <u>th</u>	+/-0.100	1.0"	✓			
16.7 <u>th</u>	+/-0.100	16.7"	✓			
15.5 <u>th</u>	+/-0.100	15.5"	✓			
1.4	+/-0.100	1.4"	✓			
2.0	+/-0.100	2.02"	✓			
0.070	Min	0.086"	✓			

Measured by: DAS 07 9-89 Date: 14/10/27

Audited by: PD Date: 14.10.28

Preliminary Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	14.07.14	New Issue	KJ	<u>MA</u>



RELEASED
2014-10-08

D4941-4LXX AFT RH FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 64
- 7) WEIGHT: 1.9 lbs
- 8) THERMOFORM PER QSI 022 USING MOLD DT9993 TRIM PER MOLD LEAVING FINISHED EDGES
- 9) MINIMUM THICKNESS AFTER FORMING IS 0.070"

ATTN-10-16
125617

PART NUMBER	DESCRIPTION
D4941-4L02	F6006 SUEDE/POLISHED 701 BLACK LEXAN SHEET 0.125 THICK (REF DART SPEC MLEXS 125-F6006-02)
D4941-4L08	90318 PROTECT-A-GLAZE 112 CLEAR LEXAN SHEET 0.118 THICK (REF DART SPEC MLEXS 118-90318-08)

APPROVED

DESIGN	AK	DART AEROSPACE LTD	
DRAWN	AK	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. D
MFG APPR	DL	D4941	SHEET 5 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR	DS	CABIN FLOOR PROTECTORS	NTS
DATE	14.07.25	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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